

5/30

DART AEROSPACE LTD	Work Order:	23730
Description: Bracket	Part Number:	D3199-1
# 05.07.04		
Dwg: D3199 Rev. A I	Qty:	97 100
Ref:		Page 1 of 1


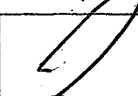

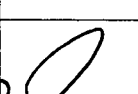
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.07.04	100
2	PG	Issue P/O: <u>2008316</u> Email or Ship DXF file to vendor Laser Cut D3199-1 bracket per Dwg D3199 Material release note is required	VA	05.07.05	100
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	DL	05/07/28	100
4	QC6	Inspect dimensions as per Dwg D3199 Identify as D3199-1	2	05-06-23	100
5	GA	Deburr if necessary	SAO	05/08/24	100
6	GB	Form as per Dwg D3199	SB	05/09/13	100
7	GA	Scribe Part number as indicated on Dwg D3199	N/A		
8	QC5	Inspect work to Step 6	J	05-09-14	100
9	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	FC	05 09 21	100
10	QC3	Inspect Powder Coat	MI	05 09 21	100
11	ST	Identify and Stock	DL	05/09/22	97
12	AC	Cost / part <u>6.24</u>	SUR	05.09-26	97
13	DC	Close W/O <u>6.08</u> Inspect Level 21	AD	05/09/26	97

PTO

Rev	Date	Change	Revised By	Approved
A	03.10.02	New Issue	KJ/RF	
B	03.10.23	Added Step 7	KJ/RF	

RELEASED

04.01.09 PF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/09/13	6	The measure .409 change to .40 \pm .030 As per attached e-mail	SB	05/09/13		 05/09/13	 05-09-14	
05-09-14	7	Part number is scribed on during laser cut process, eliminate step 7. Permanent change				 05/09/14	 05-09-14	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-08	4	Parts are 0.020" under vertical measurement of 2.571"	<i>[Signature]</i> 05-09-08	final bend dimensions are good. parts accepted.	<i>[Signature]</i> 05-09-08	<i>[Signature]</i> 05-09-08	<i>[Signature]</i> 05-09-08	<i>[Signature]</i> 05-09-08
05-09-14	6	1 part scrapped, die damage on part.	<i>[Signature]</i> 05/09/14	Scrap: destroyed	<i>[Signature]</i> 05-09-14	<i>[Signature]</i> 05-09-14	<i>[Signature]</i> 05-09-14	<i>[Signature]</i> 05-09-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/09/20

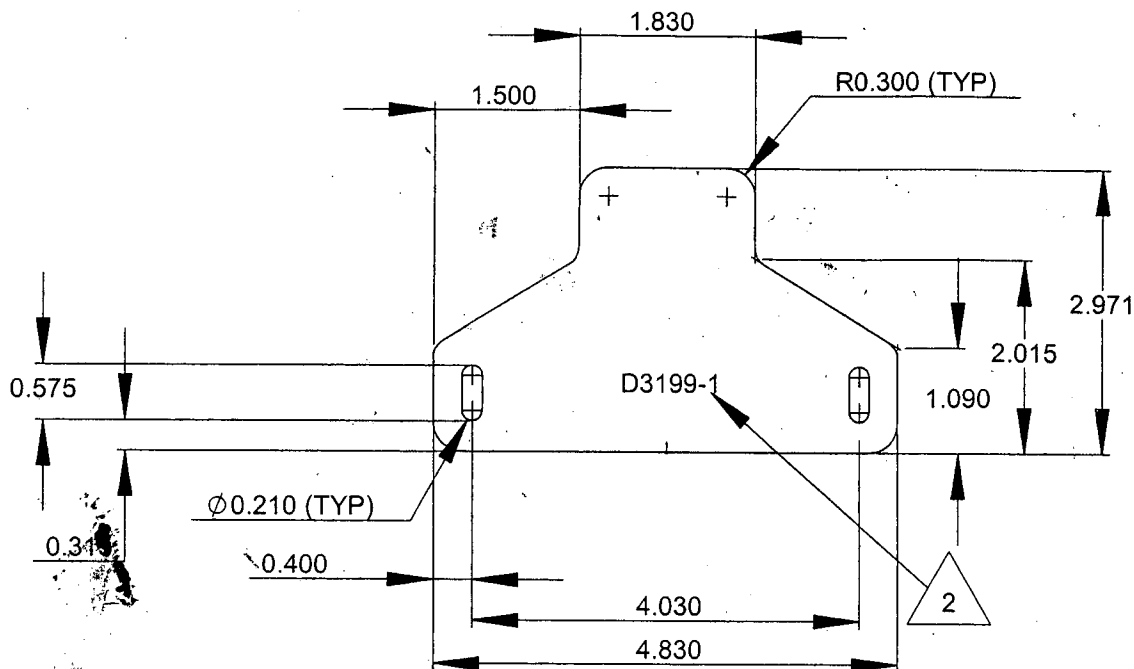
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

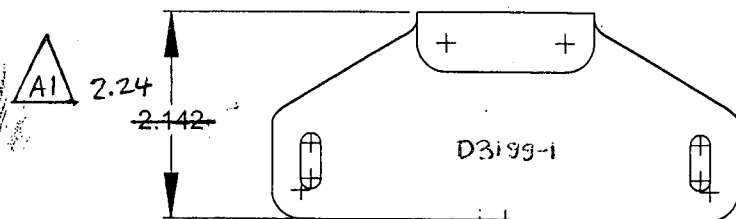


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3199	REV. A SHEET 1 OF 1
DATE 03.08.05	TITLE BRACKET	SCALE 1:2	
A	03.08.05	NEW ISSUE	
A1	04.03.01 <i>UP</i>	2.24 WAS 2.142	

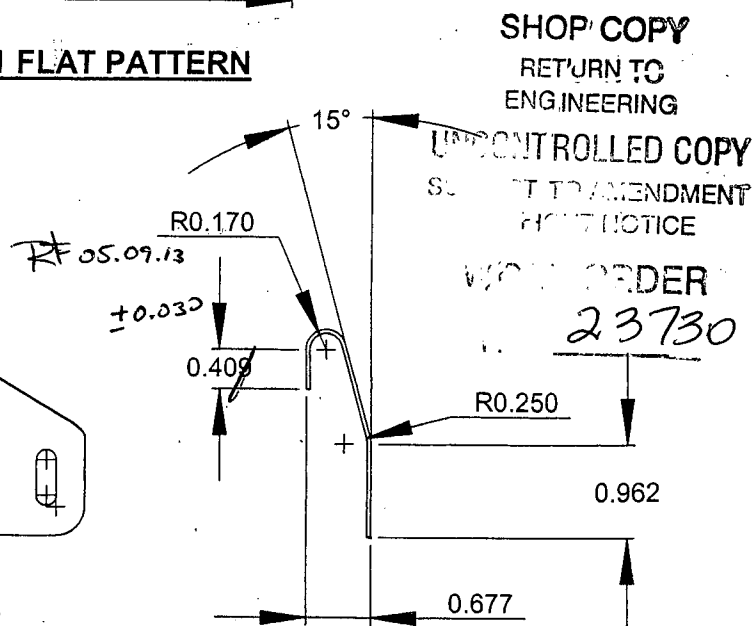
RELEASED
03.09.02 *UP*



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 30, 2005
02:06 pm

Work Order No. : 0023730
Project Name : D3199-1
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3199-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 06-30-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Doc No. 341 Indexed by 11 Nov 64

PAG. 2/ :

THYSSENKRUPP ACCEL SPECIALTIES
10 BANK STREET - WHITE PLAINS
NEW YORK
10606 USA



989 DERRY ROAD EAST SUITE 305
MISSISSAUGA, ONTARIO L5T 2J8
CANADA

STAINLESS STEEL PLATES FROM COIL

TWO KWACONS
 STAR TYPE
 TYPE IN CASE
 304
 304

WENN DIE PRODUKTION:
PRODUCE: JANE BOND
LIEFERT AN PRODUKTION:
NACH: 1. AUGUST 1968

**UNIONE DEL PROFESSIONALISMO INCLASSE
PERCORSO SINGOLO.**
MAPPE IN PLASTICA PER GIOCHI:
ITALIA CON DEDICAZIONE REGIONALE

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Wmk. - Type
Mag. # - CH 17
TID/Date - PG 16

Certificato di nascita

DATE: 05-10-2004

5. 9. 2013

.037(20GA) 304#2B

OLBERT METAL SALES LIMITED

Certificate of Mill Test Results
TO - 1000000-000

Linda Lacelle

From: "David Shepherd" <davids@dartaero.com>
To: <robertof@dartaero.com>
Cc: "Linda Lacelle" <lindal@dartaero.com>
Sent: Tuesday, September 13, 2005 10:32 AM
Subject: D3199-1

With respect to the 0.409 dimension, +/- 0.030 tolerance is acceptable for this batch.

David

9/13/2005